



Standard Specification for Steel Castings, Carbon, Low Alloy, and Stainless Steel, Heavy-Walled for Steam Turbines¹

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1. Scope

1.1 This specification covers one grade of martensitic stainless steel and several grades of ferritic steel castings for cylinders (shells), valve chests, throttle valves, and other heavy-walled castings for steam turbine applications.

1.2 Optional supplementary requirements (S1 through S5) shall apply as selected by and specified by the purchaser.

1.3 The values stated in either inch-pound units or SI units are to be regarded separately as standard. Within the text, the SI units are shown in brackets. The values stated in each system are not exact equivalents; therefore, each system must be used independently of the other. Combining values from the two systems may result in nonconformance with the specification.

2. Referenced Documents

2.1 ASTM Standards:

A 370 Test Methods and Definitions for Mechanical Testing of Steel Products²

A 488/A 488M Practice for Steel Castings, Welding, Qualifications of Procedures and Personnel³

E 94 Guide for Radiographic Examination⁴

E 125 Reference Photographs for Magnetic Particle Indications on Ferrous Castings⁴

E 142 Method for Controlling Quality of Radiographic Testing⁵

E 165 Test Method for Liquid Penetrant Examination⁴

E 186 Reference Radiographs for Heavy-Walled (2 to 4 ½-in. [51 to 114-mm]) Steel Castings⁴

E 280 Reference Radiographs for Heavy-Walled (4 ½ to 12-in. [114 to 305-mm]) Steel Castings⁴

E 446 Reference Radiographs for Steel Castings Up to 2 in. [51 mm] in Thickness⁴

E 709 Guide for Magnetic Particle Examination⁴

2.2 Manufacturers' Standardization Society of the Valve and Fitting Industry Standard:

SP-55 Quality Standard for Steel Castings for Valves, Flanges, and Fittings and Other Piping Components (Visual Method)⁶

3. Classification

3.1 The castings are furnished in the grades shown in Table 1.

4. Ordering Information

4.1 Orders for material to this specification should include the following information:

4.1.1 A description of the casting by pattern number or drawing (dimensional tolerances shall be included on the casting drawing),

4.1.2 Grade of steel,

4.1.3 Options in the specification, and

4.1.4 The supplementary requirements desired, including the standards of acceptance.

5. Melting Process

5.1 The steel shall be made by the open-hearth or electric-furnace process.

5.2 Deoxidation Practice:

5.2.1 Deoxidation of the carbon and low-alloy steel grades shall be by manganese and silicon. Furnace or ladle deoxidation with other agents is permissible with the approval of the purchaser.

5.2.2 The purchaser may specify that no aluminum be added.

5.2.3 Vacuum deoxidation is acceptable. The specific method shall be subject to approval by the purchaser.

6. Heat Treatment

6.1 Preliminary Heat Treatment—The castings may receive such preliminary heat treatment as the founder may elect to employ.

6.2 Heat Treatment for Final Properties:

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² Annual Book of ASTM Standards, Vol 01.03.

³ Annual Book of ASTM Standards, Vol 01.02.

⁴ Annual Book of ASTM Standards, Vol 03.03.

⁵ Discontinued. Replaced by E 94. See 1999 Annual Book of ASTM Standards, Vol 03.03.

⁶ Available from the Manufacturers' Standardization Society of the Valve and Fittings Industry, 127 Park St., NE, Vienna, VA 22180.

TABLE 1 Chemical Requirements

Grade	Material	Composition, %											
		Carbon	Manganese	Silicon	Phosphorus, max	Sulfur, max	Molybdenum	Chromium	Nickel	Vanadium	Columbium	Nitrogen	Aluminum
1	carbon steel	0.35 ^a max	0.70 ^a max	0.60 max	0.035	0.030	0.45-0.65
2	1 1/2% molybdenum	0.25 ^a max	0.70 ^a max	0.60 max	0.035	0.030	0.40-0.60	0.40-0.70
5	1 1/2% chromium, 1/2 % molybdenum	0.25 ^a max	0.70 ^a max	0.60 max	0.035	0.030	0.45-0.65	1.00-1.50
6	1 1/4% chromium, 1/2 % molybdenum	0.20 max	0.50-0.80	0.60 max	0.035	0.030	0.45-0.65	1.00-1.50
8	1 % chromium, 1 % molybdenum, vanadium	0.20 max	0.50-0.90	0.20-0.60	0.035	0.030	0.90-1.20	1.00-1.50	...	0.05-0.15
9	1 % chromium, 1 % molybdenum, vanadium	0.20 max	0.50-0.90	0.20-0.60	0.035	0.030	0.90-1.20	1.00-1.50	...	0.20-0.35
10	2 1/4% chromium, 1 % molybdenum	0.20 max	0.50-0.80	0.60 max	0.035	0.030	0.90-1.20	2.00-2.75
12	9 % chromium, 1 % molybdenum, vanadium (J80490) CA6NM martensic chromium nickel	0.08-0.12	0.30-0.60	0.20-0.50	0.02 max	0.010 max	0.85-1.05	8.0-9.5	0.40 max	0.18-0.25	0.06-0.10	0.03-0.07	0.04 max

^a For each 0.01 % reduction in carbon below the maximum specified, an increase of 0.04 percentage points of manganese over the maximum specified for that element will be permitted up to 1.00.



6.2.1 *Normalizing*—The castings shall be heated to and held at the proper temperature for a sufficient time to effect the desired transformation and withdrawn from the furnace and allowed to cool to effect complete transformation.

6.2.2 *Tempering*—The casting shall be heated to and held at the proper temperature, which shall be below the transformation range, and then cooled under suitable conditions. The tempering temperature shall not be less than 1100°F [595°C]. The minimum tempering temperature for Grade 12 shall be 1350°F [730°C].

6.2.3 *Stress Relieving*—The stress relieving operation shall be carried out in the same manner as tempering. The temperature shall be within 50°F [28°C], but not exceeding the final tempering temperature.

6.3 *Stainless Steel Casting*:

6.3.1 *Normalizing*—The castings shall be heated to 1850°F [1010°C] minimum, held sufficiently at that temperature to uniformly heat the castings, and air cooled to below 200°F [93°C].

6.3.2 *Tempering*—The castings shall be final tempered from 1050 to 1150°F [565 to 620°C].

6.3.3 *Stress Relieving*—The stress relieving operation shall be performed in the same manner as tempering. Temperature shall be between 1050°F [565°C] and 1150°F [620°C].

7. Chemical Composition

7.1 The steel shall conform to the requirements as to chemical composition prescribed in Table 1.

8. Tensile Requirements

8.1 Tensile properties shall conform to the requirements listed in Table 2 as determined by the test specimen set forth in Section 9.

8.2 Tension tests shall be performed in accordance with Test Methods and Definitions A 370.

9. Number of Tests and Retests

9.1 One tension test shall be made from each heat in each heat-treatment charge and from each casting on which attached coupons are specified. The bar from which the test specimen is taken shall be heat treated with the casting represented.

9.2 If any test specimen shows defective machining or develops flaws, it shall be discarded and another specimen substituted from the same heat.

9.3 If the results of the mechanical tests for any lot or casting do not conform to the requirements specified, the founder may reheat treat and retest such lot or casting.

10. Test Specimen

10.1 Tension test specimens and samples for microexamination may be taken from coupons conforming substantially to the dimensions shown in Fig. 1 and from the locations in the coupon as indicated in Fig. 1. These coupons shall have been cast attached to the castings, except as provided in 10.2, and have remained attached, without partial severing, until the completion of the heat treatment for final properties.

10.2 If, in the opinion of the manufacturer, the design of any casting is such as to preclude the use of an attached coupon, then the tension test specimen and sample for microexamination for that casting may be taken from a coupon attached to a special block. The coupon shall conform substantially to the dimensions shown in Fig. 1 and shall have remained attached, without partial severing, to its special block until after all heat treatment for final properties.

10.3 Test specimens may be cut from heat-treated castings instead of from test coupons when agreed upon between the manufacturer and the purchaser.

10.4 Tension test specimens shall be machined to the form and dimensions of the standard round 2-in. [50-mm] gage-length specimen shown in Fig. 5 of Test Methods and Definitions A 370.

11. Inspection

11.1 The inspector representing the purchaser shall have free entry, at all times while work on the contract of the purchaser is being performed, to all parts of the manufacturer's works that concern the manufacture of material ordered. The manufacturer shall afford the inspector all reasonable facilities to satisfy him that the material is being furnished in accordance with this specification. All tests (except product analysis) and inspection shall be made at the place of manufacture prior to shipment, and shall be so conducted as not to interfere unnecessarily with operation of the works.

12. Rejection and Rehearing

12.1 Any rejection based on tests made in accordance with Sections 7 or 8, or both, shall be reported to the manufacturer within 60 days from the receipt of samples by the purchaser.

TABLE 2 Tensile Requirements

Grade	Material	Tensile Strength, min, ksi [MPa]	Yield Strength, min, ksi [MPa]	Elongation in 2 in. [50 mm] min, %	Reduction of Area, min, %
1	carbon steel	70 [485]	36 [250]	20.0	35.0
2	½ % molybdenum	65 [450]	35 [240]	22.0	35.0
5	½ % chromium, ½ % molybdenum	70 [485]	40 [275]	22.0	35.0
6	1¼ % chromium, ½ % molybdenum	70 [485]	45 [310]	22.0	35.0
8	1 % chromium, 1 % molybdenum, vanadium	80 [550]	50 [345]	18.0	45.0
9	1 % chromium, 1 % molybdenum, vanadium	85 [585]	60 [415]	15.0	45.0
10	2¼ % chromium, 1 % molybdenum	85 [585]	55 [380]	20.0	35.0
12	9 % chromium, 1 % molybdenum, vanadium	85 [585]	60 [415]	20.0	...
(J80490)					
CA6NM	martensitic chromium nickel	110 [760]	80 [550]	15.0	35.0

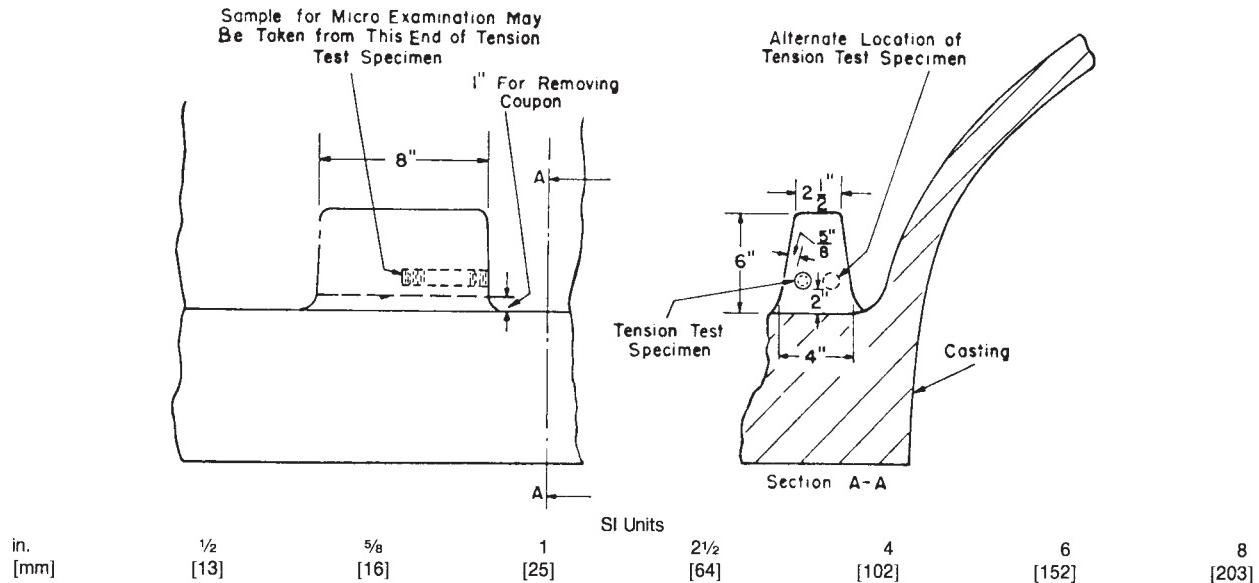


FIG. 1 Dimensions and Location of Test Coupons for Turbine Castings

12.2 Material that shows injurious defects subsequent to its acceptance at the manufacturer's works will be rejected, and the manufacturer shall be notified.

12.3 Samples tested in accordance with Section 7 that represent rejected material shall be preserved for 60 days from the date of transmission of the test report. In case of dissatisfaction with the result of the tests, the manufacturer may make claim for a rehearing within that time.

13. Certification

13.1 The manufacturer shall submit to the purchaser a certified record of the results of the chemical analysis and mechanical tests, together with a statement that all the requirements of this specification (including year date) have been met.

14. Product Marking

14.1 Pressure-containing castings, made in accordance with any of the grades of steel covered by this specification, shall be marked for material identification with the ASTM symbols for the grade of alloy steel (Grade 1, Grade 2, etc.) and the heat number or heat identification. Marking shall be positioned so as not to impair the usefulness of the castings.

15. Quality Assurance

15.1 *Surface Finish*—The castings shall be clean when offered for inspection. A standard practice which may be used as a basis for visual inspection is SP-55.

15.2 *Soundness*—The degree of soundness and the method for its determination shall be subject to agreement between the manufacturer and the purchaser. Castings may be produced in

accordance with Supplementary Requirement S2, Supplementary Requirement S3, Supplementary Requirement S4, or any combination of these.

15.3 *Welding*—Assembly welds and repair welds shall be made using procedures and welders qualified under Practice A 488/A 488M.

15.3.1 Welding shall be accomplished with a filler material known to produce weld deposits having a chemical composition and mechanical properties compatible with those of the castings.

15.3.2 Welds shall be inspected to the same quality standards as are used to inspect the castings.

15.3.2.1 When castings are produced with Supplementary Requirement S2 specified, welds shall be inspected by magnetic particle examination to the same standards as are used to inspect the castings.

15.3.2.2 When castings are produced with Supplementary Requirement S3 specified, welds shall be inspected by radiography to the same standards as are used to inspect the castings.

15.3.3 Welds shall receive at least a stress-relief heat treatment. A complete heat treatment consisting of a normalize and temper may be required for certain welds, subject to agreement between the manufacturer and purchaser.

15.3.4 When methods involving high temperatures are used in the removal of discontinuities, casting shall be preheated to at least the minimum temperatures in Table 3.

16. Keywords

16.1 carbon steel; low-alloy steel; stainless steel; steam turbines; steel castings



TABLE 3 Minimum Preheat Temperatures

Grade	Thickness, in. [mm]	Minimum Preheat Temperature, °F [°C]
1	over 1 [25]	175 [80]
	1 [25] and under	50 [10]
2	over $\frac{5}{8}$ [16]	250 [120]
	$\frac{5}{8}$ [16] and under	50 [10]
5	over $\frac{5}{8}$ [16]	250 [120]
	$\frac{5}{8}$ [16] and under	50 [10]
6	over $\frac{1}{2}$ [13]	300 [150]
	$\frac{1}{2}$ [13] and under	50 [10]
8	over $\frac{1}{2}$ [13]	300 [150]
	$\frac{1}{2}$ [13] and under	50 [10]
9	over $\frac{1}{2}$ [13]	300 [150]
	$\frac{1}{2}$ [13] and under	50 [10]
10	over $\frac{1}{2}$ [13]	400 [200]
	$\frac{1}{2}$ [13] and under	300 [150]
(J80490) CA6NM	all thicknesses	400 [200]
	all	50 [10]

SUPPLEMENTARY REQUIREMENTS

Any of the following supplementary requirements may become a part of the specification when specified on the inquiry or invitation to bid, and when made a part of the purchase order or contract after mutual agreement by the manufacturer and the purchaser on the exact standards to be applied to each method of inspection.

S1. Microstructural Requirements

S1.1 There shall be no microstructural requirements for Grade 1.

S1.2 The microstructural requirements of grades, other than Grade 1, may be specified by the purchaser.

S1.3 If microstructural requirements are specified by the purchaser, he shall furnish suitable standards to serve as a satisfactory basis for acceptance or rejection.

S1.4 If microstructural requirements are specified, the sample for examination may be taken from the end of the broken tension test specimens.

S2. Magnetic Particle Inspection

S2.1 The purchaser may specify magnetic particle inspection of castings made in accordance with this specification.

S2.2 If magnetic particle inspection is specified, the purchaser shall designate the zones of the casting to be so inspected.

S2.3 If magnetic particle inspection is specified, the purchaser shall designate acceptance standards for each type of discontinuity, preferably in accordance with Reference Photographs E125.

S2.4 Magnetic particle inspection shall preferably be performed in accordance with Guide E 709.

S2.5 The circular or coil method of overall magnetization or the wet method of magnetic particle inspection, or both, may be used subject to agreement between the manufacturer and purchaser.

S3. Radiographic Inspection

S3.1 The purchaser may specify radiographic inspection of castings made in accordance with this specification.

S3.2 If radiographic inspection is specified, radiography shall be performed in accordance with Guide E 94. The quality level of the radiographic images may be controlled by specifying adherence to Method E 142.

S3.3 If radiographic inspection is specified, the purchaser shall designate the areas of the castings to be so inspected.

S3.4 If radiographic inspection is specified, the purchaser shall designate acceptance standards for each type of discontinuity in each area of the castings to be so inspected.

S3.5 If radiographic inspection is specified, the basis for acceptance shall be subject to agreement between the manufacturer and the purchaser. The types and severity levels of discontinuities may be judged by reference to three ASTM standards: (1) Reference Radiographs E 446, (2) Reference Radiographs E 186, and (3) Reference Radiographs E 280.

S4. Examination of Weld Preparation

S4.1 Magnetic particle or liquid penetrant examination of cavities prepared for welding shall be performed to verify removal of those discontinuities found unacceptable by the inspection method specified for the casting. The method of performing the magnetic particle or liquid penetrant test shall be in accordance with Guide E 709 or Test Method E 165. Unless other degrees of shrinkage or types of discontinuities found in the cavities are specified, Type II, Internal Shrinkage, of Reference Photographs E 125 of Degree 2 in sections up to



2 in. [50.8 mm] thick and of Degree 3 in sections over 2 in. g/kg] of steel.
thick shall be acceptable.

S5. Aluminum Restriction (Carbon and Low-Alloy Steel)

S5.1 Aluminum shall not be added directly or as a constituent of other deoxidizers in an amount exceeding $\frac{1}{2}$ lb/ton [0.25

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